

Work Order ID 58066

April 22, 2010 2:19:10 PM



Page 1

Item ID: D4048-042

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug Assembly, RH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-4-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4048

A

100



Small Fab

Small Fab

Memo

ASSEMBLE AS PER DWG D4048

0.00

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

-042

120



Packaging

Packaging

Identify as per dwg & Stock Location: 960

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan

Code

Accept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

Memo

0.00

10/05/12 HJ

MF
10-5-12

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NOTE: Date & initial all entries

Picklist Print

April 22, 2010 2:19:04 PM

Page 1
J

Work Order ID: 58066



Parent Item: D4048-042



Parent Item Name: Mounting Lug Assembly, RH

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP Rev:A as per dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-14A



Bolt

Purchased

No

100

Each

129.0000

4.0000

1114582



④

SS 10/05/10 ②

Warehouse

Location

Main Warehouse

ST358

Loc Qty

Loc Code

129

113359

129

AN960JD416



Washer

WAS 1149 D6 443J

Purchased

No

100

Each

0.0000

4.0000



④ SS 10/05/10 ②

D4048-1



Mounting Lug

Manufactured

No

Warehouse

Location

Main Warehouse

ST468

Loc Qty

Loc Code

1

55967

1

D4048-4



Mounting Lug

Manufactured

No

100

Each

1.0000

2.0000



② SS 10/05/10 ②

Warehouse

Location

Main Warehouse

WA

Loc Qty

Loc Code

1

55642

1

B 53080

②

SS 10/05/10 ②

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Picklist Print

Page 2

April 22, 2010 2:19:09 PM

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Parent Item: D4048-042



Parent Item Name: Mounting Lug Assembly, RH

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP Rev:A as per dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4048-9 		Manufactured		No		100	Each	0.0000	8.0000		8 SB 18/05/10 (2)	
Bushing MS21042L4 		Purchased		No		100	Each	1,364.000	4.0000			
Nut												

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse ST139	2	
111827	2	
Main Warehouse ST300	862	
113422	112	
114108	742	
9063	8	
Main Warehouse ST463	500	
114416	500	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

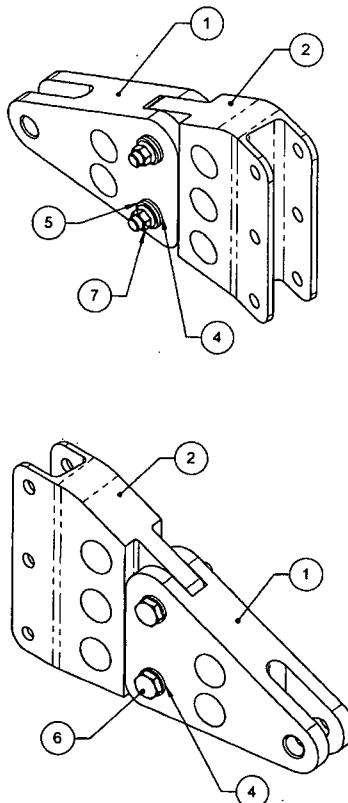
D

C

C

B

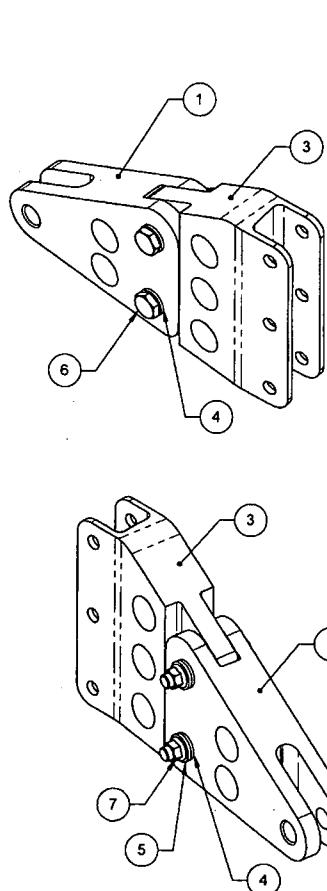
B



D4048-041 MOUNTING LUG ASSY (SHOWN)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4048-041/-042: 1.16 lbs
- 8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)



D4048-042 MOUNTING LUG ASSY (SHOWN)

ITEM	QTY -041	QTY -042	P/N	Description
	X		D4048-041	MOUNTING LUG ASSY
		X	D4048-042	MOUNTING LUG ASSY
1	1	1	D4048-1	MOUNTING LUG
2	1		D4048-3	MOUNTING LUG
3		1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960JD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

SHOP DRAWING
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 580de

RELEASED
2010-02-16
M

A	NEW ISSUE		RF	10.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKSLEY, ONTARIO, CANADA		
CHECKED	<i>90</i>	DRAWING NO.		REV. A
MFG. APPR.	<i>90</i>	D4048		SHEET 1 OF 9
APPROVED	<i>90</i>	TITLE		SCALE
DE APPR.	<i>90</i>	MOUNTING LUG ASSY		NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE, OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

A

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

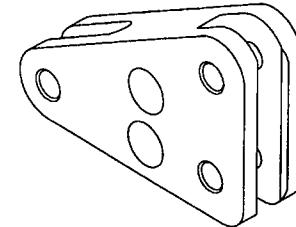
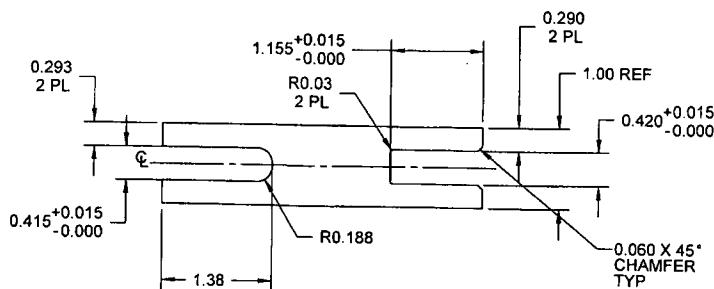
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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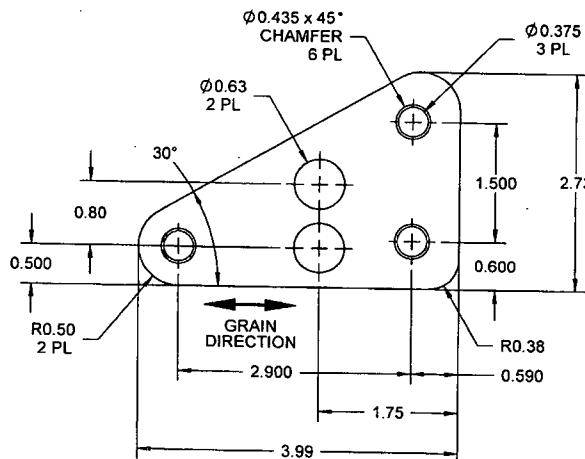
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



C



w/o 58066

D4048-1 MOUNTING LUG

RELEASED
2010-02-16
MT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø0.315 HOLES PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99		
MFG. APPR.	99		REV. A
APPROVED	99		SHEET 2 OF 9
DE APPR.	99	TITLE	SCALE
DATE	10.01.29	MOUNTING LUG ASSY	NTS

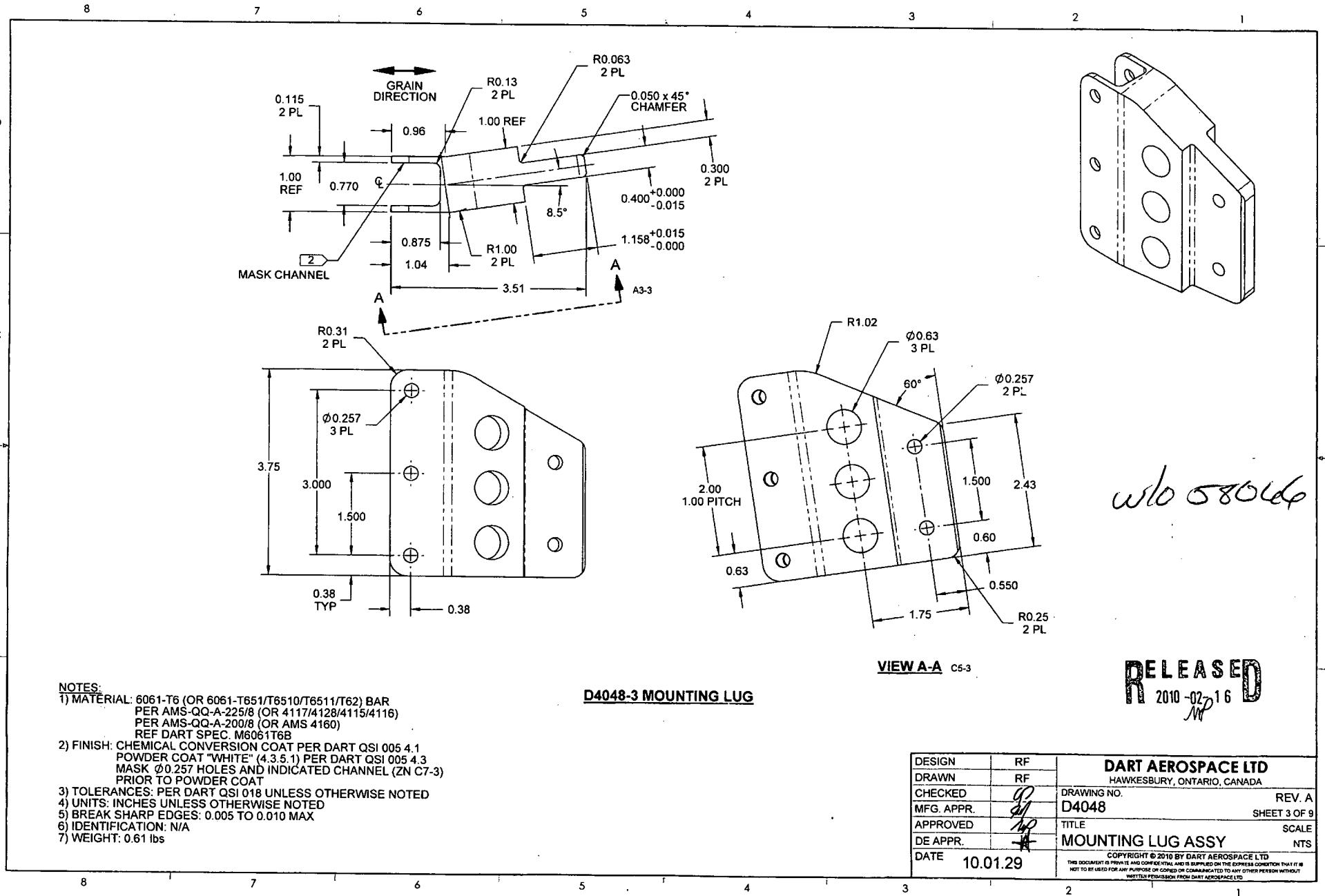
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W/O:		WORK ORDER CHANGES					
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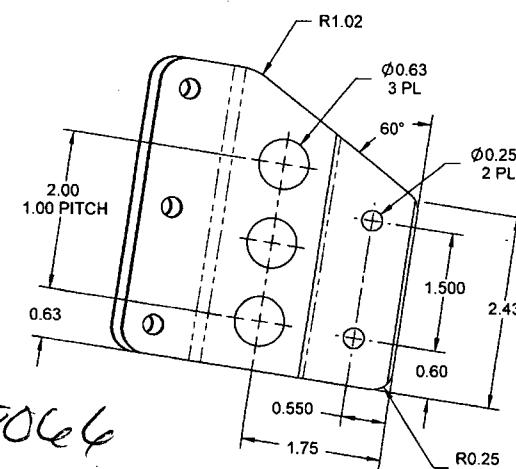
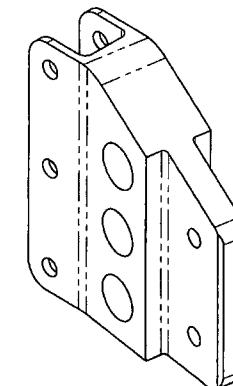
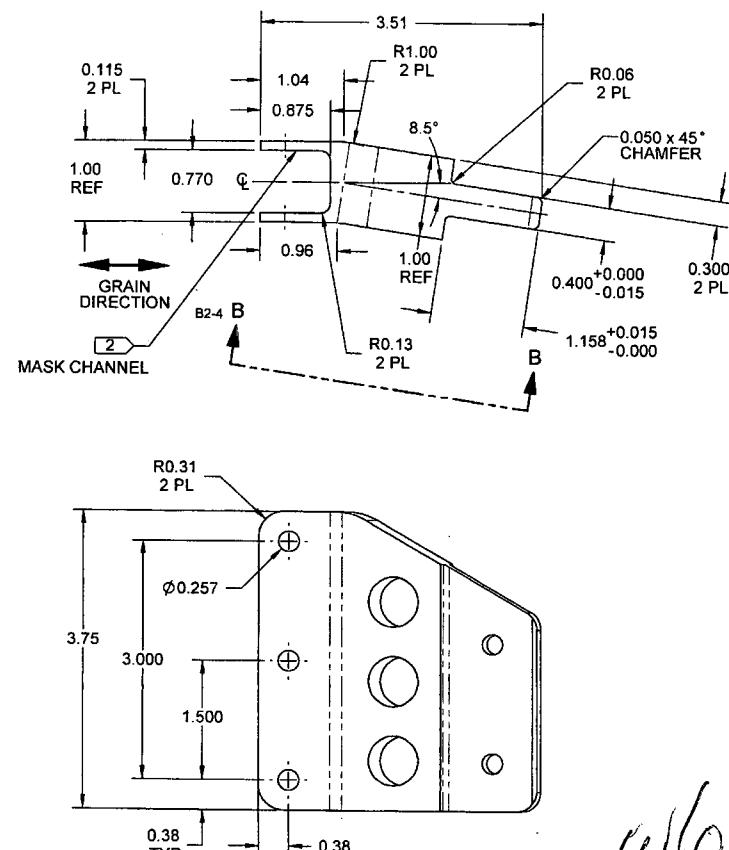


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NOTE: Date & initial all entries



Wb 58064

5
RELEASED
2010-02-16
MP

D4048-4 MOUNTING LUG

NOTES:

- 1) MATERIÁL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QC-A-200/8 (OR AMS 4160) REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø 0.257 HOLES AND INDICATED CHANNEL (ZN C7-4) PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.61 lbs

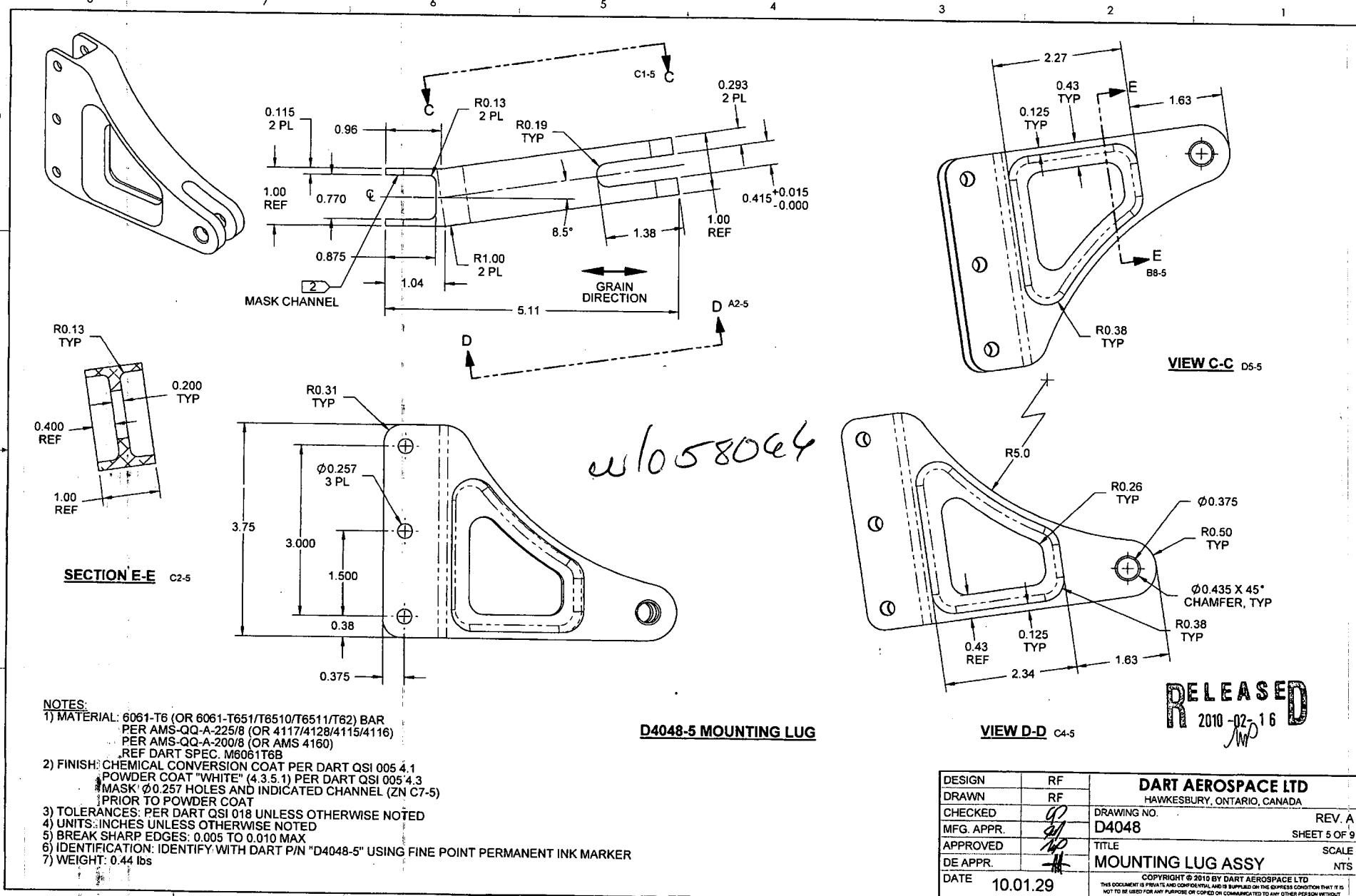
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DRAWN	RF			
CHECKED	90	DRAWING NO.	REV. A	
MFG. APPR.	91	D4048	SHEET 4 OF 5	
APPROVED	AP	TITLE	SCALE	
DE APPR.	A	MOUNTING LUG ASSY NTS		
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CHECKED	90	DRAWING NO.	
MFG. APPR.	31	D4048	REV. A
APPROVED	11	SHEET 5 OF 9	
DE APPR.	11	TITLE	SCALE
DATE	10.01.29	MOUNTING LUG ASSY	

NTS

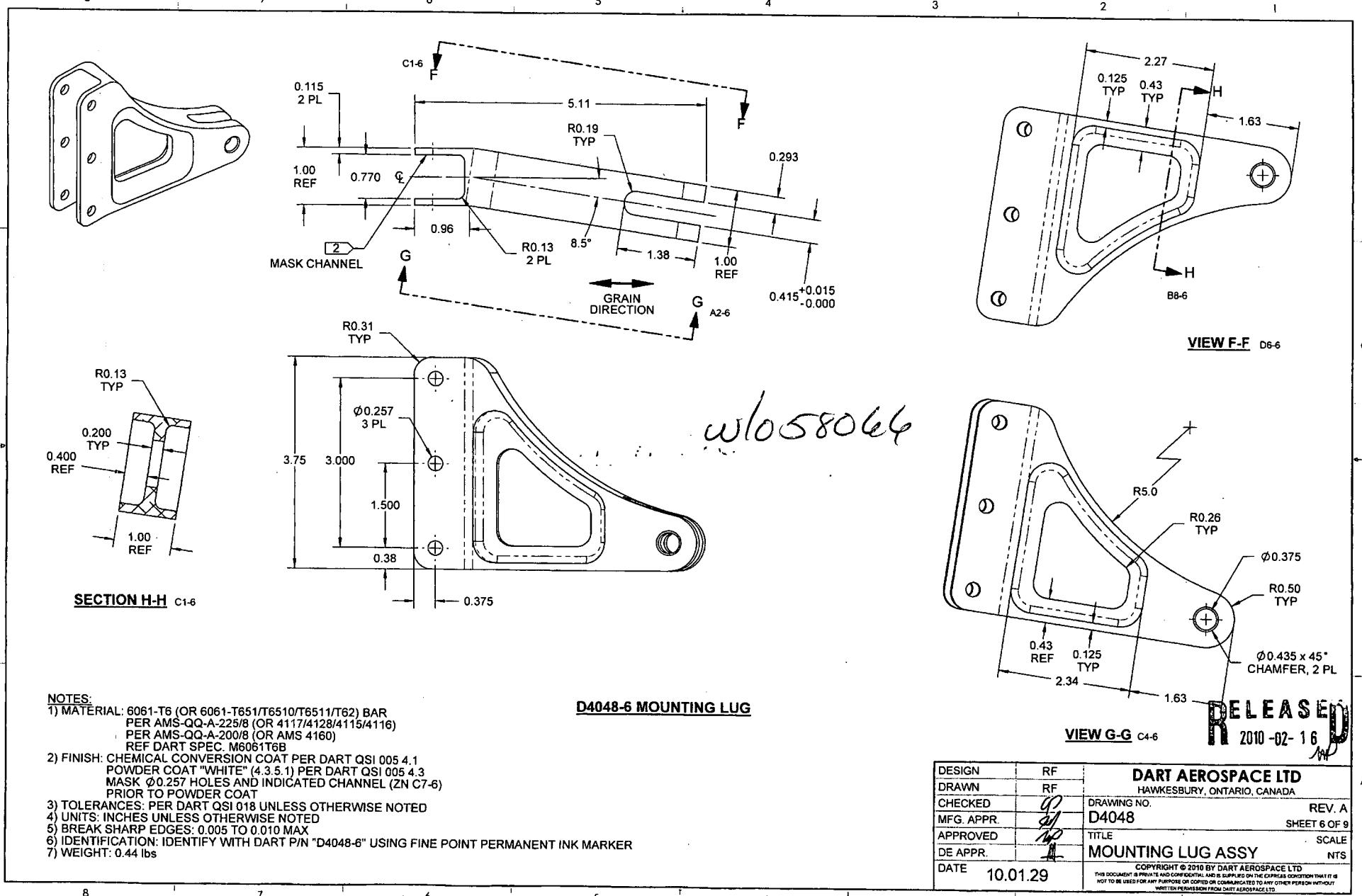
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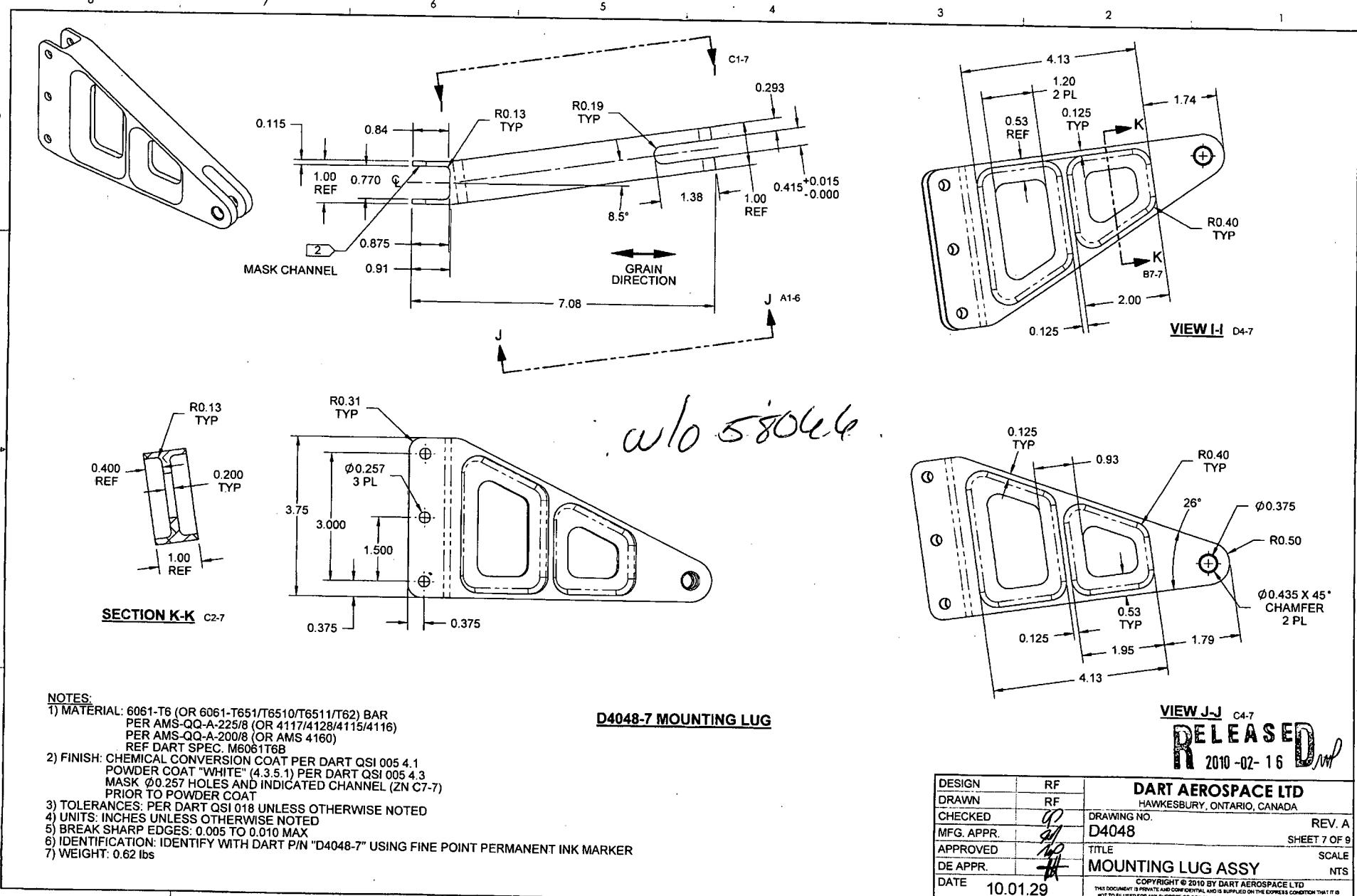
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2010-02-16

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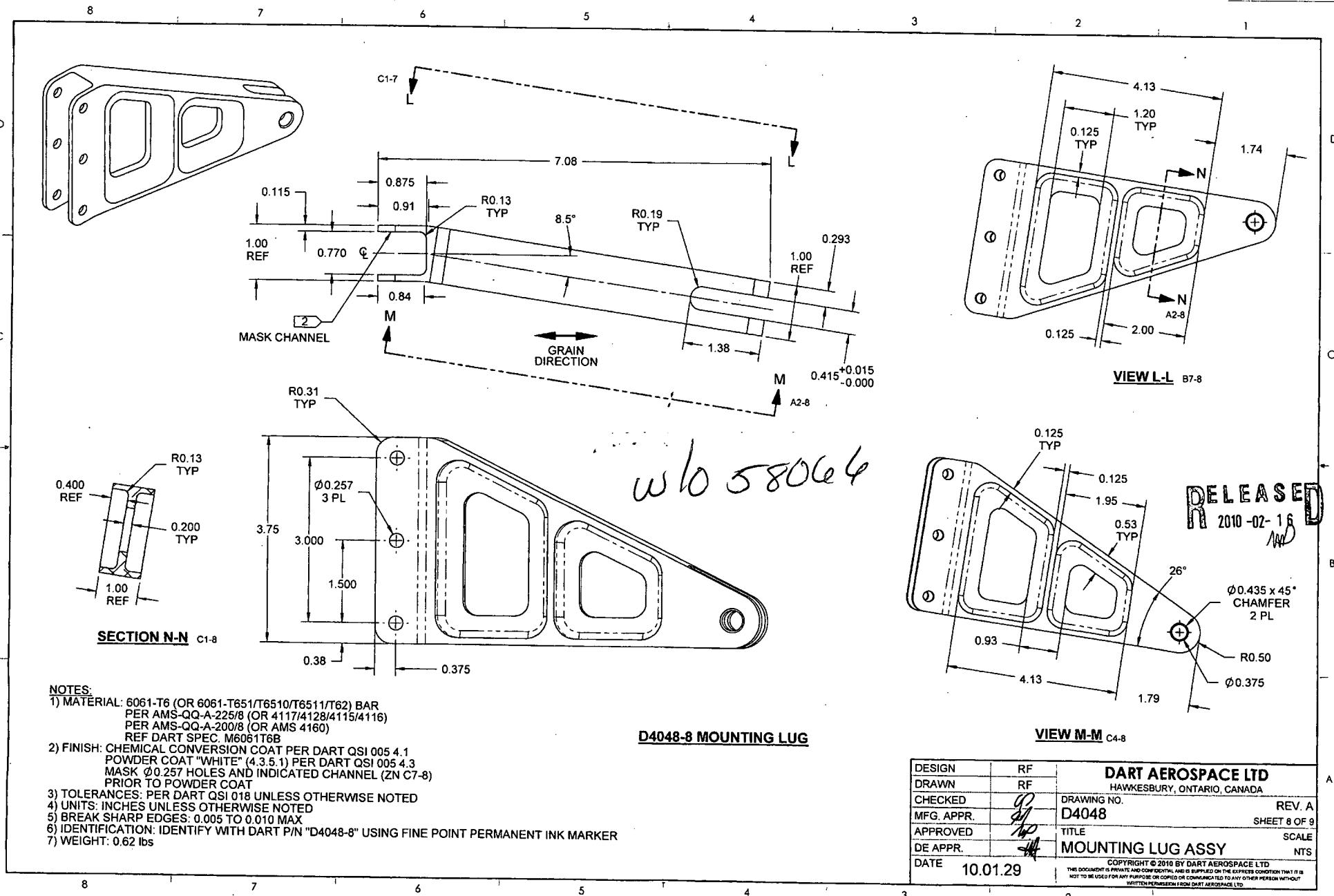
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CHECKED	<i>99</i>	DRAWING NO.	
MFG. APPR.	<i>31</i>	REV. A	
APPROVED	<i>10</i>	D4048	
DE APPR.	<i>10</i>	SHEET 8 OF 9	
DATE	10.01.29	TITLE	
Mounting Lug Assy			
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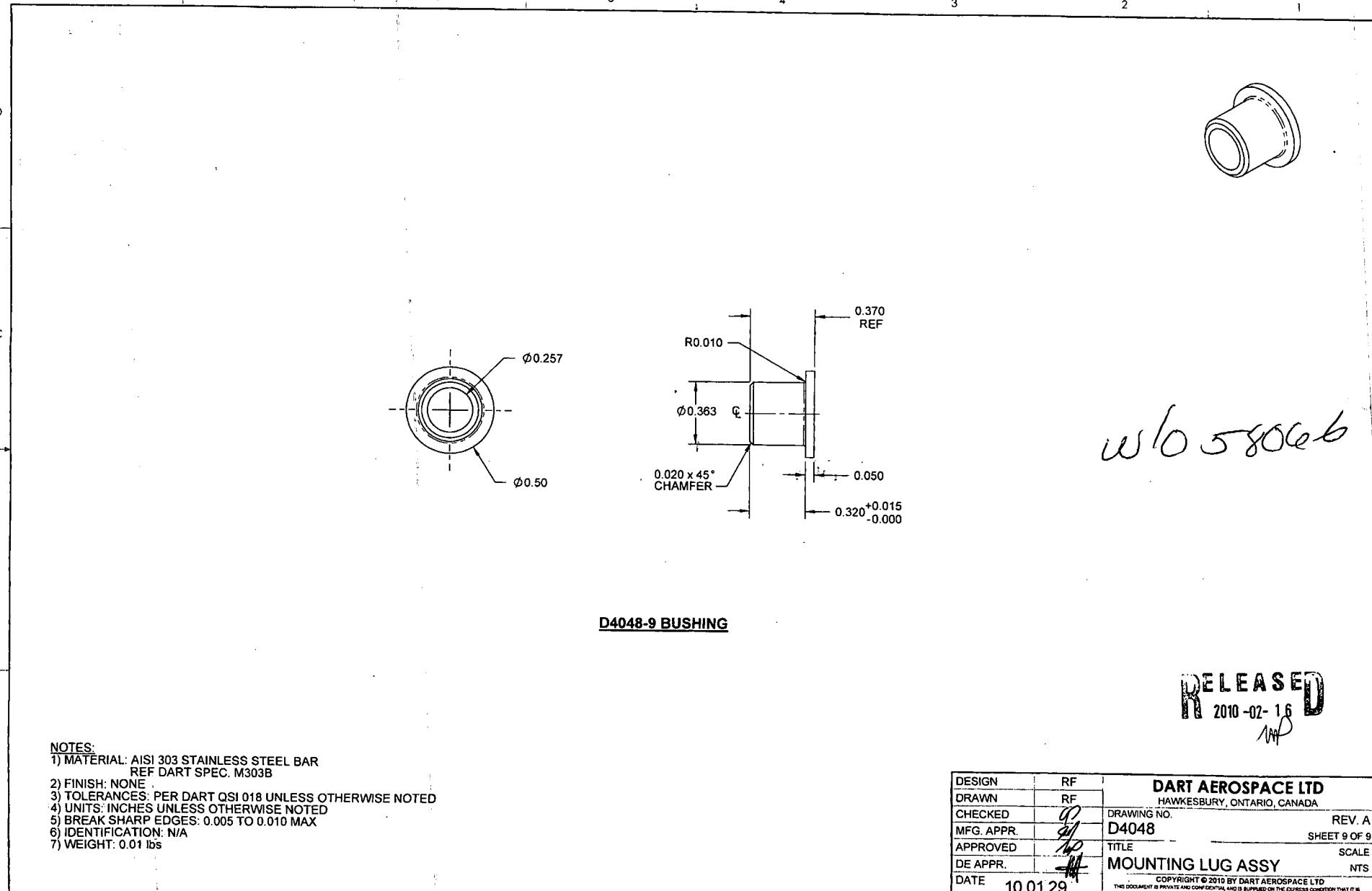
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8 7 6 5 4 3 2 1



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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>99</i>	DRAWING NO. D4048	
MFG. APPR.	<i>21</i>	REV. A	SHEET 9 OF 9
APPROVED	<i>10</i>	TITLE MOUNTING LUG ASSY	
DE APPR.	<i>11</i>	SCALE	NTS
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8 7 6 5 4 3 2 1

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Jean-Luc Menard [jmenard@dartaero.com]
Sent: May 7, 2010 10:23 AM
To: L Lacelle
Subject: FW: D4048-9 bushing - USFS basket

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: May 7, 2010 10:05 AM
To: 'Jean-Luc Menard'
Subject: FW: D4048-9 bushing - USFS basket

From: Robert Fuentes [mailto:rfuentes@dartaero.com]
Sent: May 7, 2010 10:06 AM
To: 'Mike Petsche'
Cc: 'David Shepherd'
Subject: RE: D4048-9 bushing - USFS basket

Hi Mike,

That was done in purpose to no over stress clamp and help on the alignment basket in hard point in the aircraft. We notice that in the installation for flight test, didn't produce a concern, because everything was secure and no movement between this two parts.

Roberto

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: Friday, May 07, 2010 6:43 AM
To: 'Robert Fuentes'
Cc: 'David Shepherd'
Subject: D4048-9 bushing - USFS basket

Roberto,

Could you double check the length of these bushings? Sylvie is trying to assemble the basket mounts. She discovered that the bushings as they are are too long to allow the bolts the secure the mounts correctly. Essentially the bushing are bottoming out. They seem to be about .030" too long.

Could you please take a quick look?

Thanks

Mike Petsche
DART Aerospace
Design Manager

613-632-5200
514-833-1657

No virus found in this incoming message.
Checked by AVG - www.avg.com
Version: 9.0.819 / Virus Database: 271.1.1/2858 - Release Date: 05/07/10 02:26:00